

Date: \* Wednesday, 2/20/2008 4:24:45 PM  
User: Kim Johnston

# **Process Sheet**

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 37552	Part Number	: D2573
Estimate Number	: 10533	Drawing Number	: D2573 REV E
P.O. Number	:	Project Number	: N/A
This Issue	: 2/20/2008 S.O. No. :	Drawing Revision	: E
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : MACHINED PARTS	Due Date	: 3/10/2008 Qty: 6 Um: Each
Previous Run	: 37284		
Written By	:		
Checked & Approved By	: <u>080221</u>		
Comment	: Est. 1 As Per RevE 06-01-27 JLM		

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
7075-T7351 8.25X7.75X2.5  
Make from D6101-007 billet for D2573  
Ensure that grain is along 7.75" length  
Batch No: B34875

7ml 08/02/07

6

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. 37552 Double check by: DJP

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove sharp edges.

7ml 08/03/06

6

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2573 & D2574

SA 1027ml 08/03/06

6

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 1027ml 08/03/06

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 08/03/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:24:45 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 37552

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

2F 08/03/10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1 08/03/12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FK 08/03/12 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-03-12

(16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

AS 08/03/13 (x6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/14

Job Completion



mi 2008/3/13

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>37552</b>
<b>Description:</b> Saddle, Aft Outboard	<b>Part Number:</b>	<b>D2573</b>
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.740	.740	.740	.740		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.500	.502	.503		
G	0.257	0.262	<del>DT8683</del>	.258	.258	.258	.258		
H	0.375	0.380	<del>DT8684</del>	.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.502	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.573	.573	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.122	4.123		
P	0.115	0.135		.126	.126	.124	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.253	.251	.251		
S	0.115	0.135		.127	.127	.128	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.243	.243	.240	.240		
W	0.115	0.135		.127	.127	.130	.130		
X	0.308	0.313		.310	.310	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.370	.367	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.624	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.253	.248	.251		
AE	1.500	1.520		1.512	1.512	1.515	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.253	.253	.255	.255		
AH	0.240	0.260		.254	.254	.251	.251		
AI	2.000	2.020		2.002	2.002	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>SA</i>	
Date: 08/03/06	

Audited by: <i>RF</i>	
Date: 08/03/10	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 37552
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.000	8.003				
F	0.490	0.510		.502	.504				
G	0.257	0.262	<del>DT8683</del>	.260	.260				
H	0.375	0.380	<del>DT8684</del>	.378	.378				
I	0.490	0.510		.500	.501				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.570				
L	1.174	1.184		.179	1.179				
M	1.365	1.375		1.376	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.123	4.124				
P	0.115	0.135		.127	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.252	.251				
S	0.115	0.135		.127	.129				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.228	3.236				
V	0.230	0.250		.239	.246				
W	0.115	0.135		.130	.129				
X	0.308	0.313		.309	.309				
Y	0.760	0.765		.766	.766				
Z	0.352	0.372		.366	.367				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.627	.627				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.249	.248				
AE	1.500	1.520		1.513	1.512				
AF	0.115	0.135		.120	.121				
AG	0.240	0.280		.260	.264				
AH	0.240	0.260		.250	.251				
AI	2.000	2.020		2.003	2.001				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

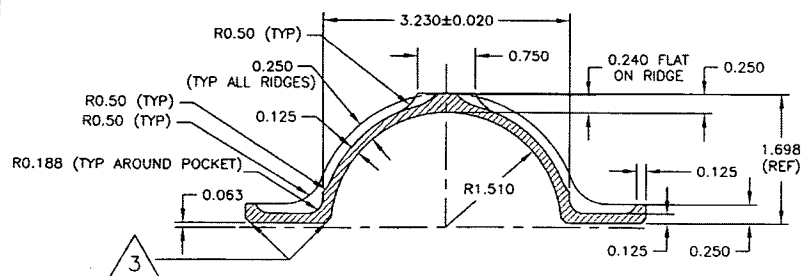
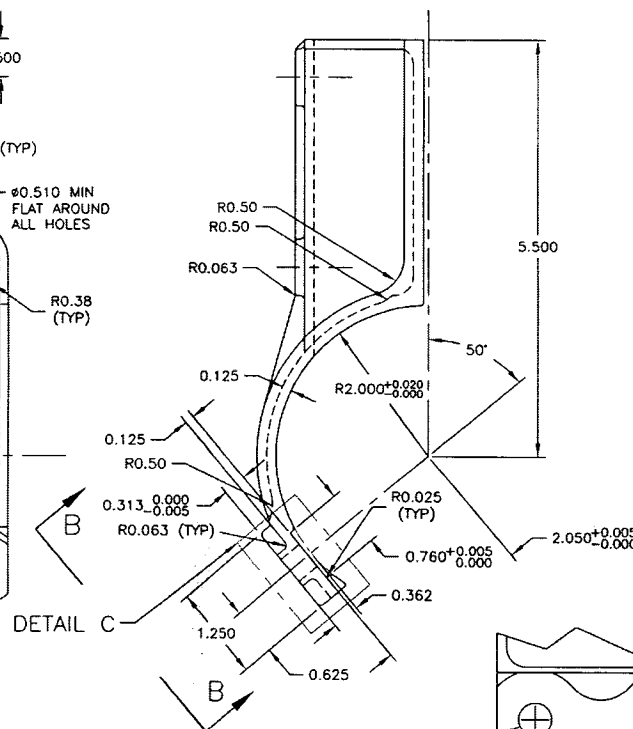
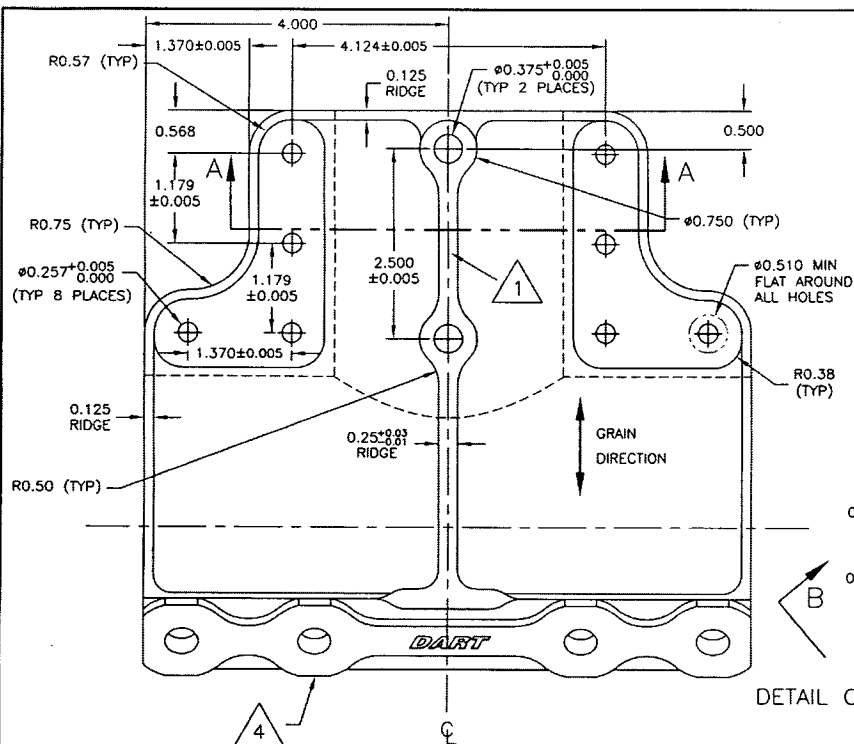
Measured by: <i>SM</i>
Date: 08/03/06

Audited by: <i>RF</i>
Date: 08/03/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>SM</i>

RELEASED

05.12.06



SECTION A-A

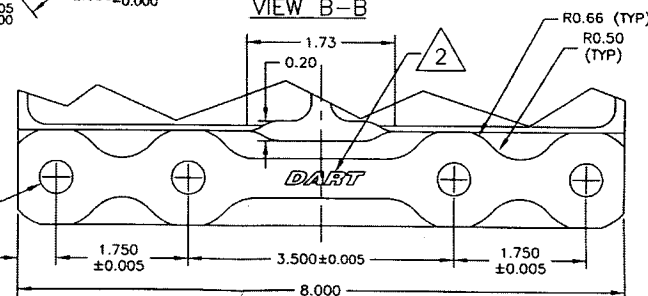
DETAIL C  
SCALE 4:3

# NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		02573
		OUTER AFT SADDLE

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